

Work Order ID 51529

August 25, 2009 1:35:26 PM



Page 1

Item ID: D2649

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Cross Bolt Spacer

Start Date: 8/28/09 Start Qty: 75.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 75.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *09-8-25* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2649	Rev B1

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

0.00

SHO 9/09/11
DTP 09/09/11
83 *Ø*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

SHO 9/09/14
DTP 09/09/11
83 *Ø*

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

SHO 9/09/14
DTP 09/09/11
83

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



Packaging

Packaging

Identify as per dwg & Stock Location:

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51529



Parent Item: D2649RevB1



Parent Item Name: Cross Bolt Spacer

Start Date: 8/28/09

Required Date: 9/11/09

Comments:

Start Qty: 75.00

Required Qty: 75.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	166.5500	22.3658			

6061-T6 RD Tube .375 x .058W

Warehouse

Location

Main Warehouse

MAT	166.55
110485	9.67
110968	3.67
111432	33.21
111944	120

Loc Qty

Loc Code

25 Pt SA 09/09/14

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	51529
Description: Cross Bolt Spacer	Part Number:	D2649
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DTP	Audited by:	JS	Prototype Approval:	N/A
Date:	09/09/11	Date:	09/09/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

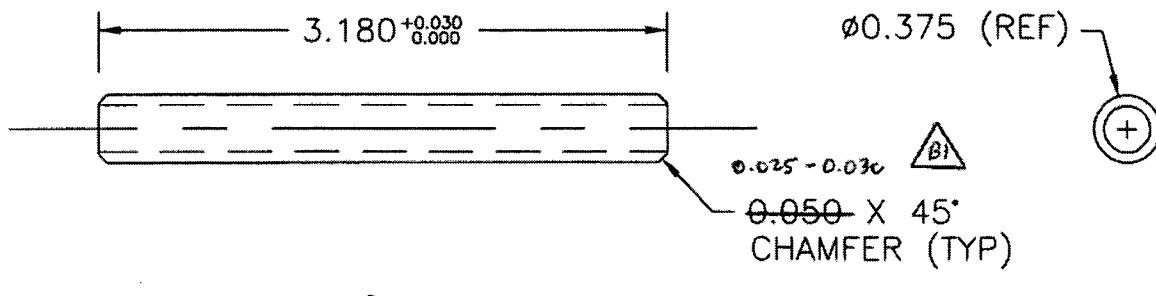
DART

DESIGN <i>DK</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DK</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1

A	97.03.25	NEW ISSUE
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER
B1	4 CP 02.06.13	REDUCE CHAMFER PER TSR 1296.

RELEASED

98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
 0.375 DIA 0.058 WALL
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5/15
Loc 29